

Date: Tuesday, 12/5/2006 8:14:48 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 6" MIRROR		
Job Number	: 29773					
Estimate Number	: 10101					
P.O. Number	: N/A			Part Number	: D2011101	
This Issue	: 12/5/2006 S.O. No. : N/A			Drawing Number	: D2011 REV. F	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: F	
Previous Run	: 27163			Material	: N/A	
Written By	: <i>[Signature]</i>			Due Date	: 12/23/2006	
Checked & Approved By	: <i>[Signature]</i>			Qty:	50 Um: Each	
Comment	: Est: J 04.09.15 Added Steps 5-7 Est: K 05.12.15 chg black sikaflex for white EC			KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <u>2639</u> <i>Loc 112104</i>	
		Purchase Grote Mirror P/N: 28043	
		Possible supplier: UAP/NAPA	<i>(50)</i>
		Material release note required	
2.0	28043	MIRROR 6"	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Mirror 6"	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	<i>Loc 112108 (50)</i>
4.0	QC6	DIMENSIONAL CHECK	 <i>Loc 112111 (50) QSP09</i>
		Comment: DIMENSIONAL CHECK	
5.0	D30141	Locknut	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Locknut Pick: Qty Part Number Description Batch 1 D3014-1 Lock nut <i>B25021</i>	

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:14:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 29773

Part Number: D2011101

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 AN960JD416L Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD416L Washer *M101237*

SAD 06/12/21

7.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

3- Inject 3ml of Sikaflex -291/-241 adhesive per hole.

Qty	Part Number	Description	Batch
9ml	N/A	Sikaflex-291/-241	<i>410210738</i>
		Expiry date	<i>02/2017</i>

M1026722
02/2007

SAD 06/12/21

4- Test assembly to 50lbs pull test after 24 hours

Start: *06/12/21* Time: *4:30*

Finish *07/01/16* Time: *2:50*

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/16 (50)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST198*

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/16 (50)

Job Completion



07/01/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.01.16	8.0	Test ASS'Y to 50lbs pull test. move AT Q&S perm. changes.	E	07.01.16		07.01.16	07.01.16

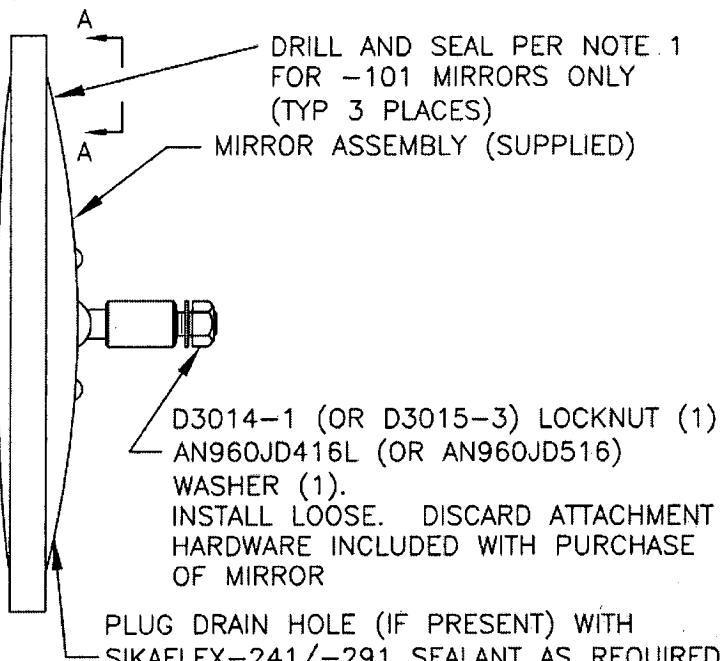
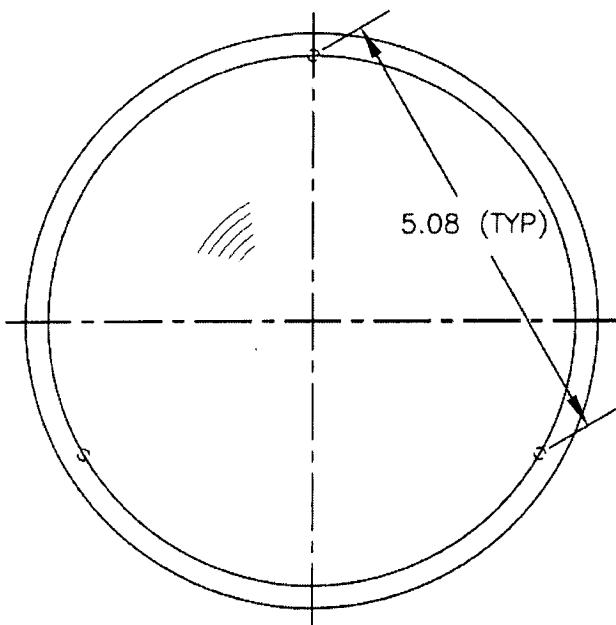
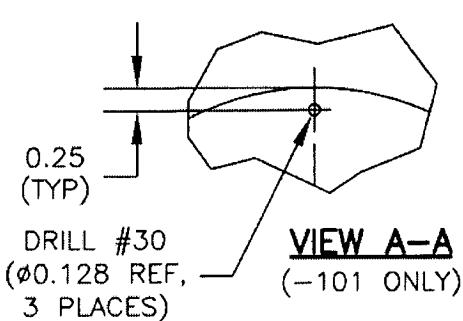
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTCOPY IS
MADE
BY
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. F
		D2011	SHEET 1 OF 1
DATE		TITLE	SCALE
04.09.10		MIRROR ASSEMBLY	1:2



PLUG DRAIN HOLE (IF PRESENT) WITH
SIKAFLEX-241/-291 SEALANT AS REQUIRED.

RELEASED
04-09-10
R

QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 29713



HAWKESBURY AUTO PARTS INC 5580661#: 861597896RT0001
4 MAIN STREET WEST EXCH:SU 6259 EXP:03/12/31
HAWKESBURY, ONT. K6A 2J2
TEL: 632-8575 FAX: 632-1539

DANGEROUS GOODS PERMIT
EXPIRY DATE:

EMERGENCY TELEPHONE NUMBER 24 HOURS
CANUTEC 613-996-6666

ACCT #	SOLD TO		DATE	TIME	STORE #	EMP #	INVOICE NO.
01601	DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7		12/08/06	14:34	060004074	31	143493
SR #			PURCHASE ORDER #		ATTENTION		
6			2539				
AD			TAX EXEMPTION: 6122-5207		TERMS: 30 DAYS CHARGE SALE		
			DELIVERY:				
PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL	
28043	GRO	GROTE	50.00	41.140	16.820	841.00 T150	

REFUNDED BY _____

Subtotal 841.00

VERIFIED BY _____

Tax 6% GST ONLY 50.46

Tax 0% 0.00

Robert Marcken
SIGNATURE
ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

TOTAL --> CHARGE SALE 891.46